

Work Order ID 110079

December-17-13 9:07:42 AM

110079

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Item ID: D3290-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: **B110079** Stop ***NS2***
 Item Name: Frame
 Start Date: 12/17/13 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C								

100	FLOW WATER JET	0.00				<u>14</u>	<u>0</u>	<u>Jm14-02-7</u>
100								
Waterjet	Memo	0.00						
FLOW CNC Waterjet	1-Cut as per Dwg D3290 (use prog. for D3290-1)							
<u>6041.063</u>	Dwg Rev: <u>C</u>							
	Prog Rev: <u>C</u>							
	2-Deburr if necessary							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				<u>14</u>	<u>0</u>	<u>Jm14-02-7</u>
110								
QC	Memo	0.00						
Quality Control								
120	QC8- Inspect parts - second check	0.00				<u>14</u>		
120								
QC	Memo	0.00						
Quality Control								

DAS
27
9-19

14/2/7

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
135	QC7-Inspect Chemical Conversion Coat	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME 10:45 OVEN TEMPERATURE 320° FINISH TIME 11:15								

1214 14-2-10

14 14-2-10

14 14-2-10

DAS 34 9.89

DAS 34 9.89

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NR2

0.00

10

14x

DAS
28

9-89

14-02-10

14-02-13

14-02-11

Picklist Print

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Work Order ID: 110079

Parent Item: D3290-1

Parent Item Name: Frame

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	738.8065	3.75	47.368421	64		Jm 14-02-7

Location

Loc Qty

Loc Code

MAT021

738.8065

123135

120.2625

124003

70.943

M124446

94

M126075

77.742

M127006

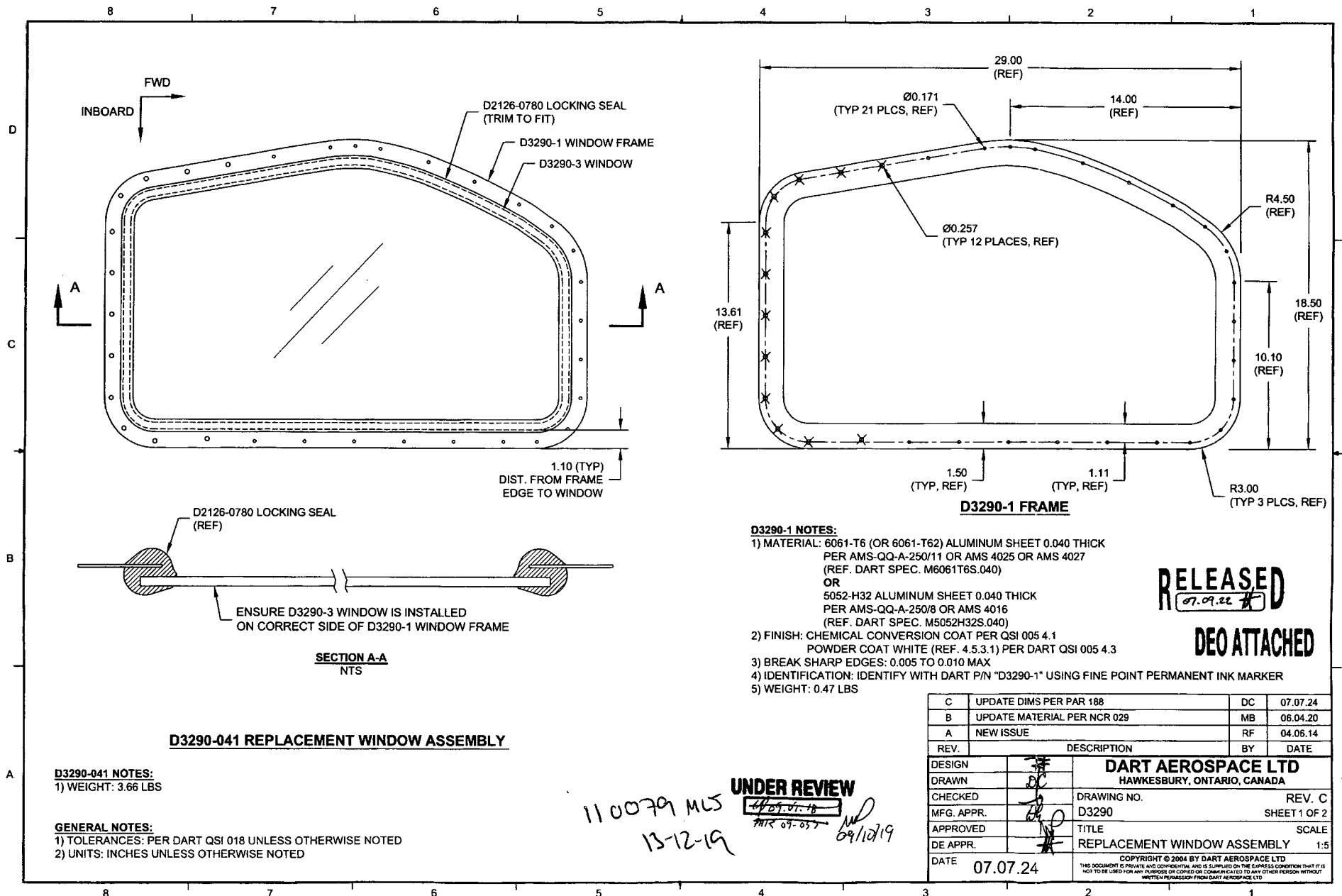
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M127420

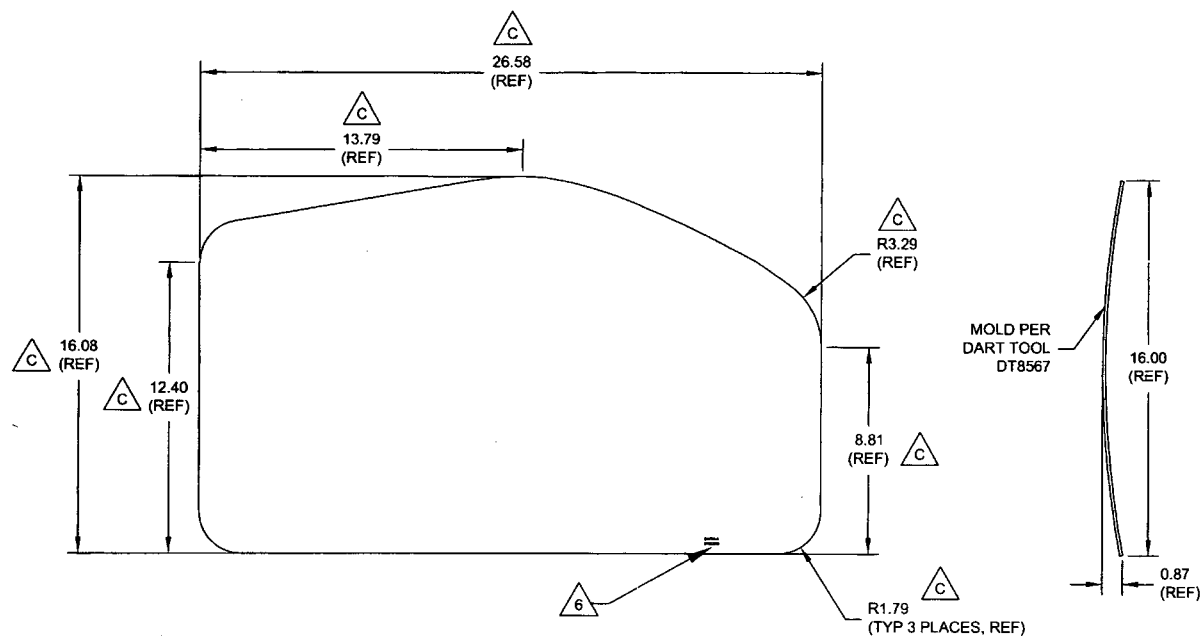
226.869

128054

128054



RELEASED
 07.09.22
DEO ATTACHED



D3290-3 WINDOW

B

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

W. J. 1/10/19
UNDER REVIEW
DEO ATTACHED
RELEASED
07.07.22 #

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>h</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
W

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